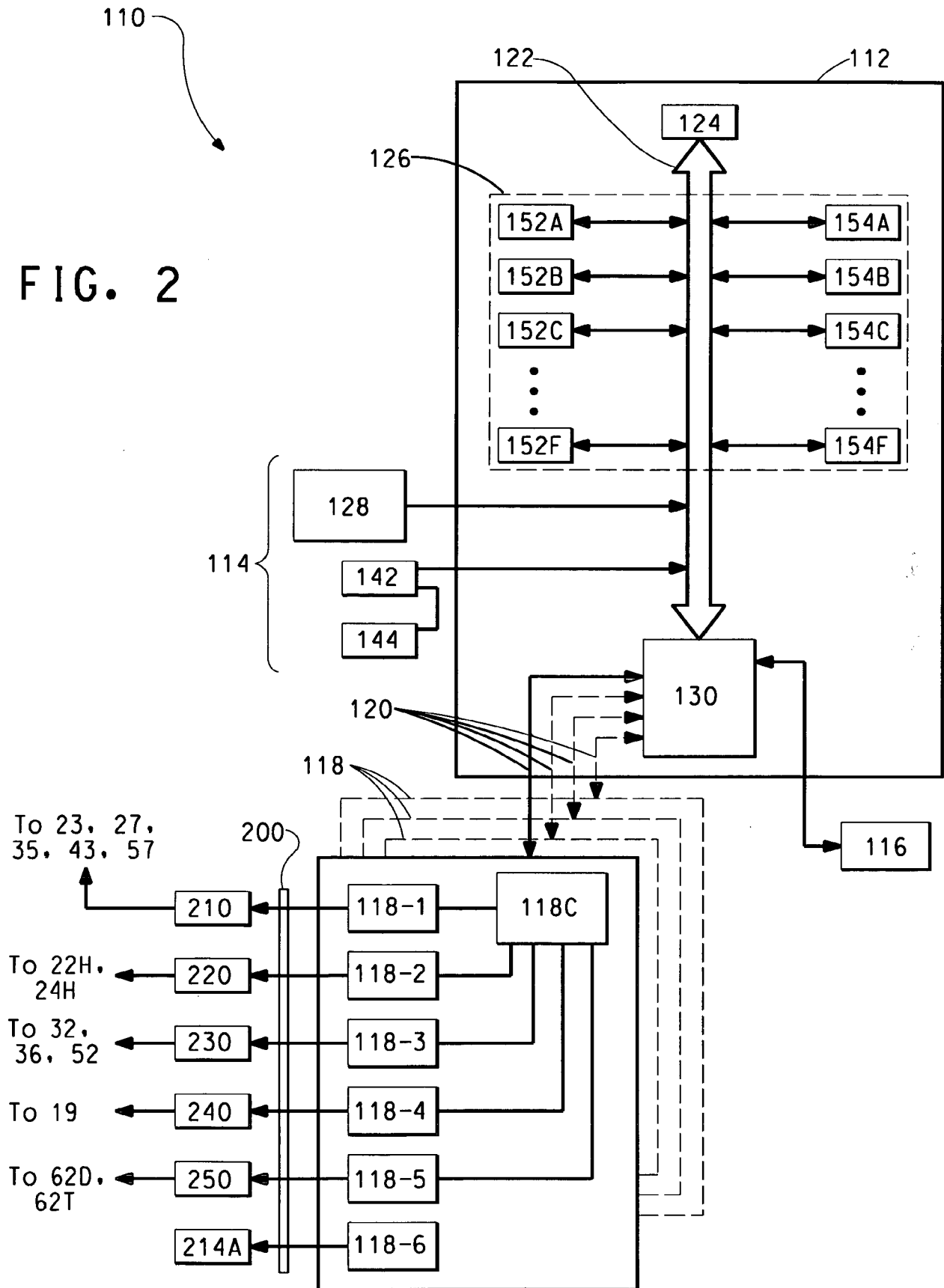


3/5

FIG. 2



Step Number

- ☐ Step 1
- ☐ Step 2
- ☐ Step 3
- ☐ Step 4
- ☐ Step 5
- ☒ Step 6
- ☐ Step 7
- ☐ Step 8
- ☐ Step 9
- ☐ Step 10

Heated Roll #2B
☒ Heated Roll #2A ☐ Rollset #2
 Speed (MPM) Temp (°C)
 Rollset #5 Speed (MPM)
 Winder Speed (MPM)
 Winder Tension (%)
 Wastefjet ☐
 Consolidation Ratio
 Consolidation Jets ☒
 Rollset #4 Speed (MPM)
 Re-Break Ratio
 Rollset #3 Speed (MPM)
 Aspirator ☐
 Wrapper Jets ☒
 Heated Roll #1B ☒ Temp (°C)
 Heated Roll #1A ☒ Temp (°C)
 Rollset #1 Speed (MPM)
 Draw Ratio
 Hot Plate ☐
 Stretch Break Ratio

Reference Rollset

- ☒ Rollset #1
- ☐ Rollset #5

Final Package Parameters

Final Package Diameter (mm)

Final Package Yarn Length (mm)

Ramp Times

Acceleration (seconds)

De-Acceleration (seconds)

Final Package Parameters

Aspiration Jet Pressure

Wrapper Jet Pressure

Consolid Jet #1 Pressure

Consolid Jet #2 Pressure

Comments

Remove Current Step

Summary of Data

Recipe Name/Description

FIG. 3

Main Parameters	Step	1	2	3	4	5	6
Production Take-up Drive					ON		
Production Take-up	m/min	0.00	0.00	0.00	207.40	312.70	312.70
Take-up Tension	%	0.0	0.0	0.0	0.0	0.0	0.0
Roll-set 5	m/min	0.00	0.00	0.00	207.40	312.70	312.70
Consolidation Ratio	1/x	0	0	0	0.98	0.98	0.98
Roll-set 4	m/min	0.00	0.00	101.46	211.63	319.08	319.08
Re-Break Ratio	1/x	0	0.00	1.83	2.33	2.82	2.82
Roll-set 3	m/min	0.00	0.00	55.44	90.83	113.15	113.15
Stretch Break Ratio	1/x	0.00	0.00	2.20	2.93	3.65	3.65
Roll-set 2	m/min	16.80	20.00	25.20	31.00	31.00	31.00
Draw Ratio	1/x	2.10	2.50	2.80	3.10	3.10	3.10
Roll-set 1	m/min	8.0	8.0	9.0	10.0	10.0	10.0
Aspirator Jet		Off	Off	On	On	On	On
Consolidation Jet		Off	Off	Off	On	On	On
Waste Jet		Off	Off	Off	Off	On	Off
Winder		Off	Off	Off	Off	Off	On

FIG. 4